

Work Order ID 59319

Tuesday, June 01, 2010 8:59:50 AM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 6/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: PHDate: 10-6-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0:00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

SAD 10-06-17

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 3 M113328

6- grind weld flush where indicated on dwg

~~2~~ 3A 10/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

③ 10.06.21

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.06.21

③ X3

-041

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAP 10-06-21

③

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Page 3

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Stop



Item Name: Rib Assembly (Basket Lid, RH)

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 *[Signature]*N10-6-22
(3)

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 01, 2010 8:59:56 AM

Page 1

Work Order ID: 59319

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Start Date: 6/1/2010

Required Date: 6/4/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	19.0000	1	2			



Spacer Bushing



B58974 @ 5/10/06/21

Location

Loc Qty

Loc Code

WA

19

58406

19

M304TS0.750W.065

Purchased

No

100

f

1,053.322

1.7808

3.749053



SAD 10-06-17

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

53.32232

112398

0

114482

53.32232

WA

1000

114520

1000

3.74905 + 1.874525

= 5.623575

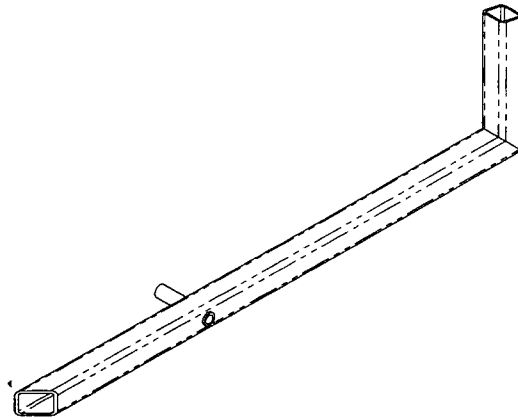
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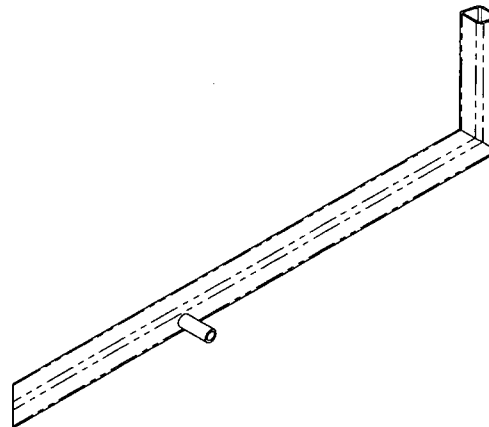
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39319
AS10-5-01

RELEASED
08/11/18 MJP

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A SHEET 1 OF 3
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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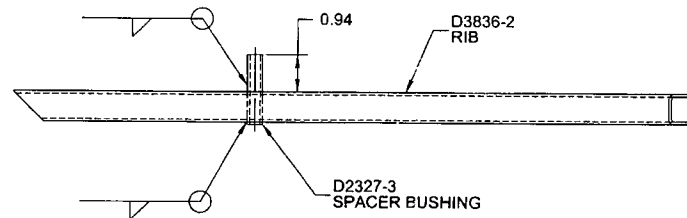
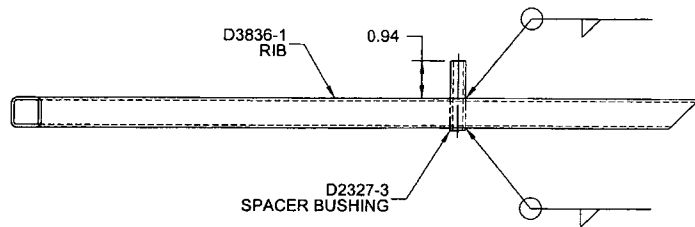
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

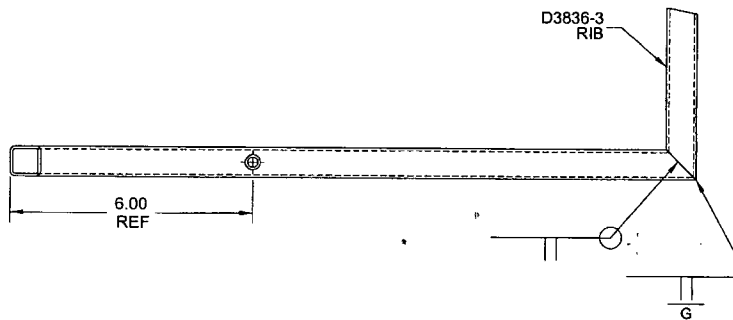
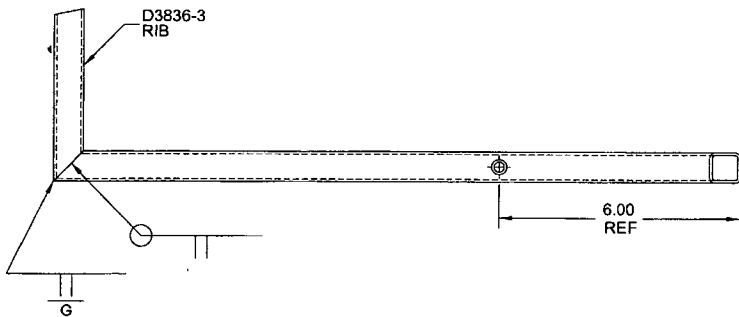
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

WLO 59367

RELEASED
08/11/84

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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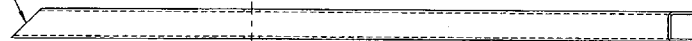
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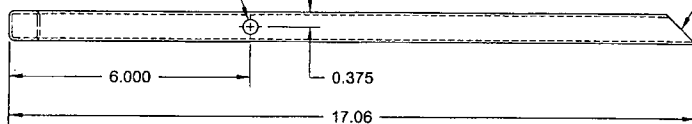
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NOTE: Date & initial all entries

0.75 X 45°
CHAMFER



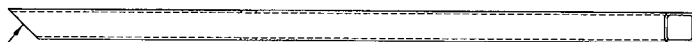
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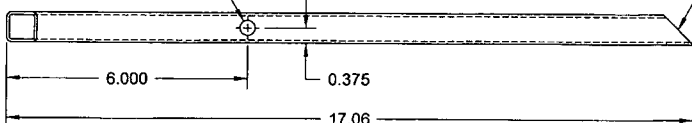
0.75 X 45°
CHAMFER

D3836-1 RIB

0.75 X 45°
CHAMFER

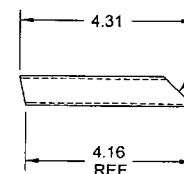


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0.75 X 45°
CHAMFER

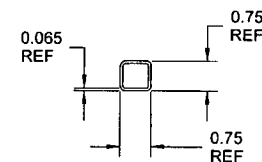
D3836-2 RIB



0.75 X 45°
CHAMFER

D3836-3 RIB

tw/10 59360



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN	1	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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